Work Order ID 64093

Wednesday, November 24, 2010 8:51:45 AM

Item ID: D2803-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bracket Assembly

Start Date: 11/24/2010 **Start Qty:** ~~4~~ 6.00 **Cust Item ID:**

Required Date: 11/30/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** P **Date:** 10-11-24 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2803	Rev B								
100	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Press D2805-2 into arm as per Dwg D2803								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 9:30 ☐OVEN TEMPERATURE: 320° ☐FINISH TIME: 10:00.								

10/12/20 6

10/12/20

6

6 10-12-21.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 64093

Wednesday, November 24, 2010 8:51:45 AM

Item ID: D2803-042 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bracket Assembly

Start Date: 11/24/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 11/30/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00				MM	10	12	21 (6)
Quality Control									
140		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00				EJS	10/01/04		(6)
Small Fab	Press D2809 into arm as per Dwg D2803								
150		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00				EJS	10/01/04		(6)
Small Fab	Assemble as per Dwg D2803.								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Required Date: 11/30/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 149	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

S 11/01/04

+6 -042

11/1/04

CK 11/01/05

mf 11-01-04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, November 24, 2010 8:51:50 AM

Work Order ID: 64093

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 11/24/2010 **Required Date:** 11/30/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP F□05.03.30□MS21043-3 was MS21042L3□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2 Bracket		Manufactured	No			100	Each	2.0000	1	4			
						B64457		(6)					
				Location			**Loc Qty**		**Loc Code**				
				ST148			2						
					56187		2						
D2805-2 Stop		Manufactured	No			100	Each	4.0000	1	4			
				Location			**Loc Qty**		**Loc Code**				
				ST024			4						
					58528		4			4	B64454	(20)	
NAS1515H3 Washer		Purchased	No			100	Each	174.0000	4	16			
				Location			**Loc Qty**		**Loc Code**				
				ST277			174						
					111268		4						
					115675		70			24			
					115935		100						
AN3C16A Bolt		Purchased	No			150	Each	97.0000	2	8			
				Location			**Loc Qty**		**Loc Code**				
				ST352			97						
					111193		6						
					111425		41			12			
					115835		50						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, November 24, 2010 8:51:50 AM

Work Order ID: 64093

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 11/24/2010 **Required Date:** 11/30/2010

Start Qty: 4.00 **Required Qty:** 4.00

D2809 Bushing	Manufactured	No	150	Each	37.0000	1	4	11/01/04

Location		Loc Qty	Loc Code	
ST025		37		
	34035	12		
	46438	1		
	47733	24		6

MS21043-3 Nut	Purchased	No	150	Each	2,191.000	2	8	11/01/04

Location		Loc Qty	Loc Code	
FG		76		
	103691	76		
ST301		2115		
	112314	2115		12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	64093
Description: Bracket	**Part Number:**	**D2803-2**
Inspection Dwg: D2803 **Rev:** B		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000					
1.420	+/-0.001					
Ø0.191	+0.005/-0.000					
Ø0.507	+0.000/-0.001					
Ø0.507 x [illegible].250	+0.000/-0.001					
12.411	+/-0.010					
6.933	+/-0.010					
0.250	+/-0.010					
0.875	+0.000/-0.001					
0.250	+0.000/-0.005					
0.125	+/-0.010					
0.125	+/-0.010					
0.500	+/-0.010					
0.125	+/-0.010					
0.188	+/-0.010					
0.562	+/-0.010					
0.125	+/-0.010					

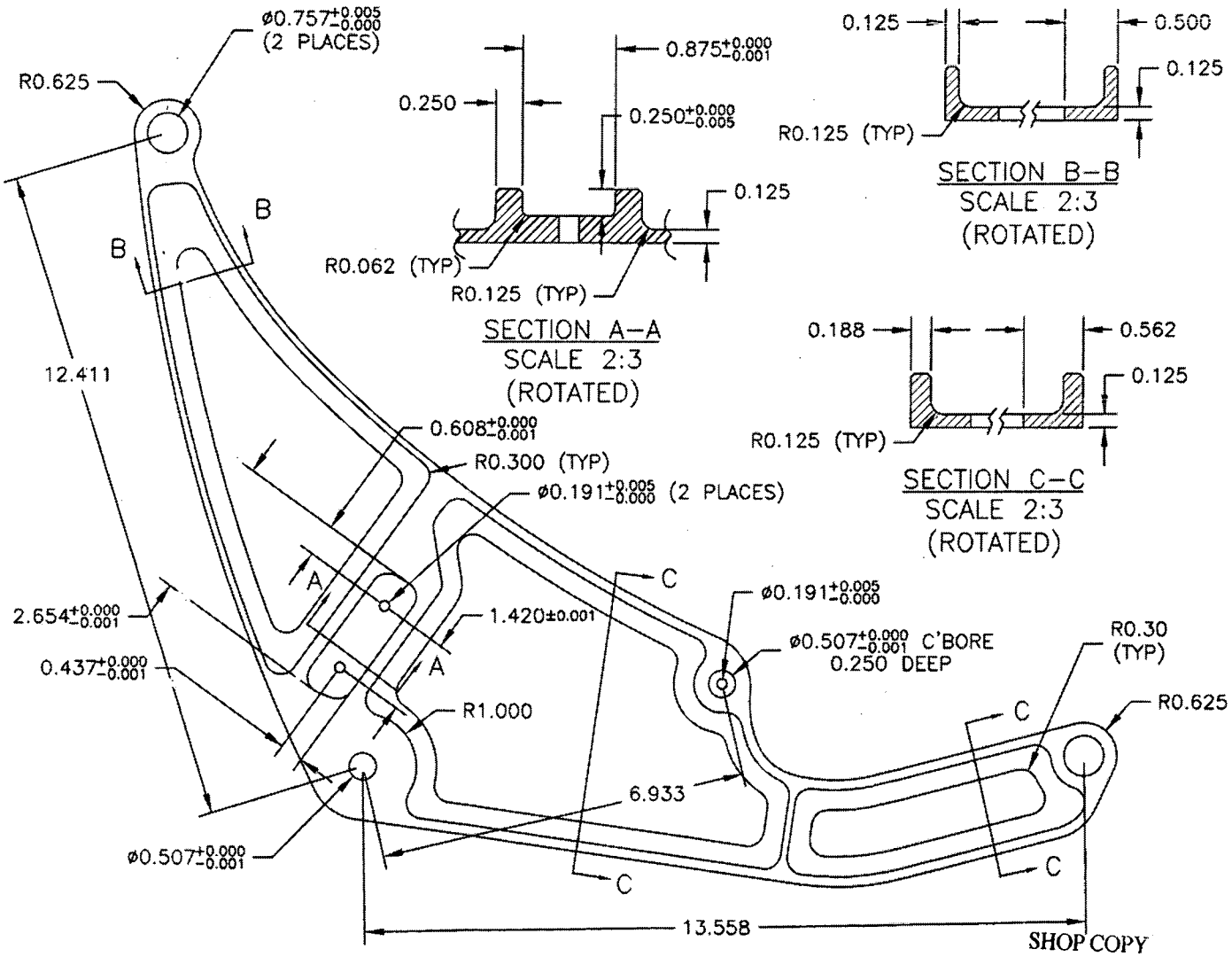
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 1 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044

RELEASED
05.03.11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44093
BS 10-11-24

D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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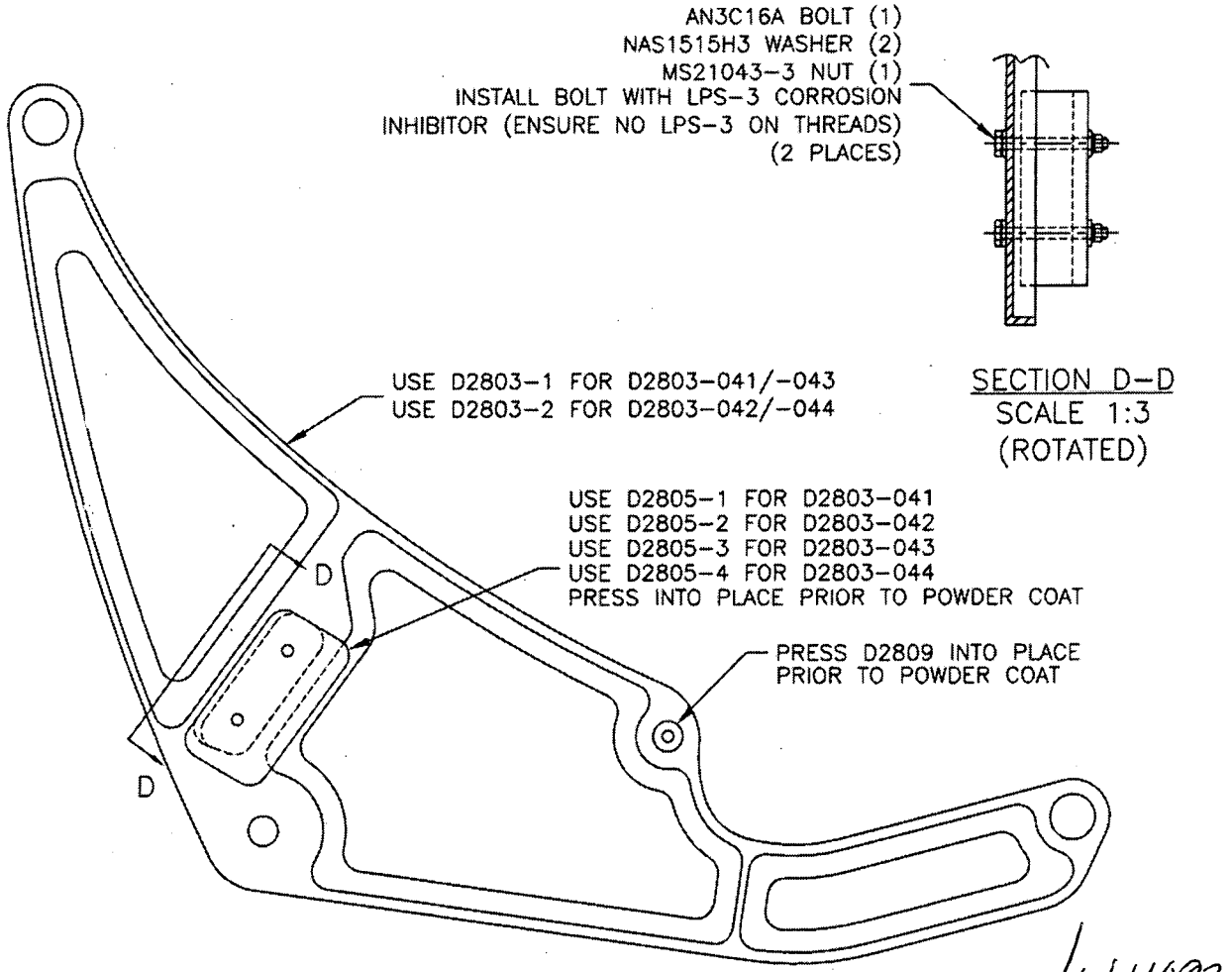
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3



w/o 64093

RELEASED
05.03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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